

Work Order ID 73406

Wednesday, August 31, 2011 3:06:05 PM



Page 1

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 8/31/2011 Start Qty: 20.00

Required Date: 9/16/2011 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/08/31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3500

rev. C

12,01.03

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 36 Double check by: DA ☐ 1-Machine Step No 1 P.K. 11/12/24
per Folio FA641 and inspect per attached Dimension Sheets ☐ 2-Machine Step
No 2 per Folio FA641 and inspect per attached Dimension Sheets ☐ 3-Machine
Step No 3 per Folio FA641 and inspect p

36 / DA 11/12/23 16 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

36 / DA 11/12/23 16 0
P.K. 11/12/24

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

36 11.12.28 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73406

Wednesday, August 31, 2011 3:06:05 PM



Item ID: D3500-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 8/31/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

M-11-12-28

140 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *8:00* ☐ OVEN TEMPERATURE:

☐ FINISH TIME:

3200F

8:30

16X M-12/02/02

150 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10x M 12/01/02

M119480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73406

Page 3

Wednesday, August 31, 2011 3:06:05 PM

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 8/31/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp
Stamp

160

Identify as per dwg & Stock Location: 5424

0.00



Packaging

Memo

0.00

Packaging

M.C.J. 12/01/02

16

170

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 12/01/03

MF
12-01-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, August 31, 2011 3:06:03 PM

Work Order ID: 73406



Parent Item: D3500-1



Parent Item Name: Saddle

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013 		Manufactured	No			100	Each	36.0000	1	20			

Saddle Billet

Location	Loc Qty	Loc Code
MAT043	36	
59467	3	
60713	8	
61300	1	
70674	24	

73402

12
4
16

8/31 11/12/25

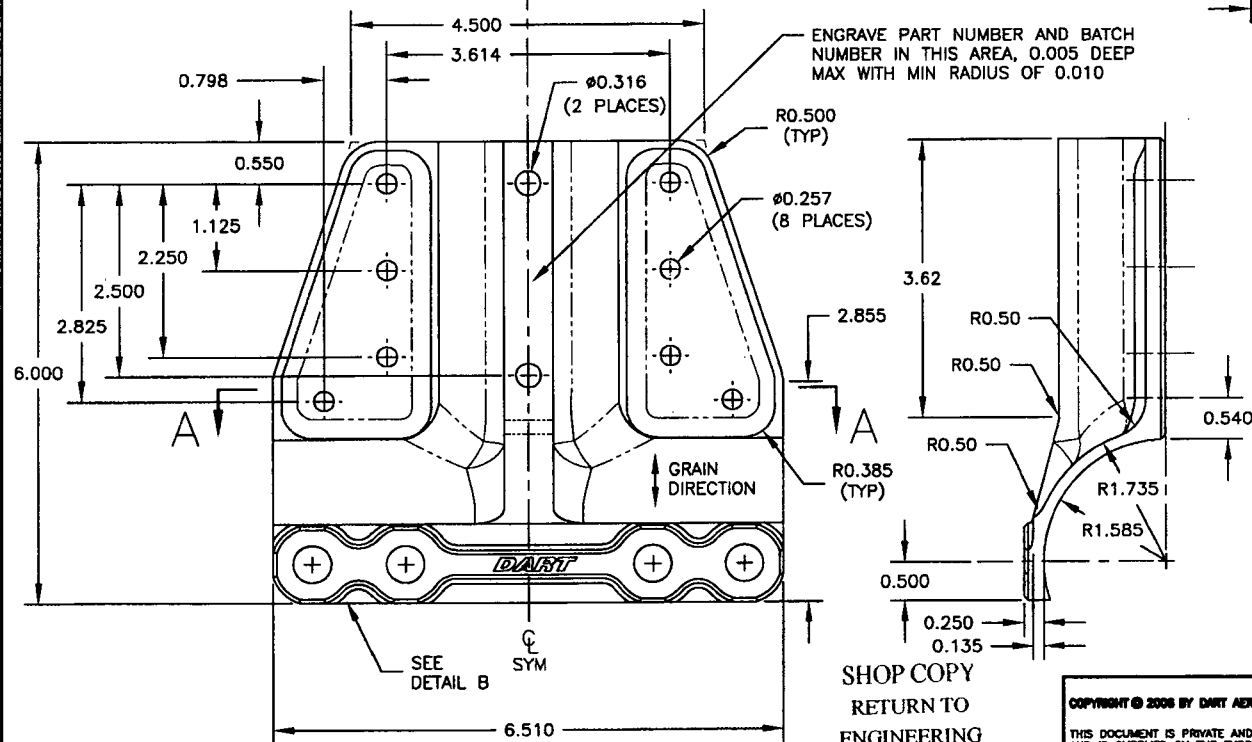
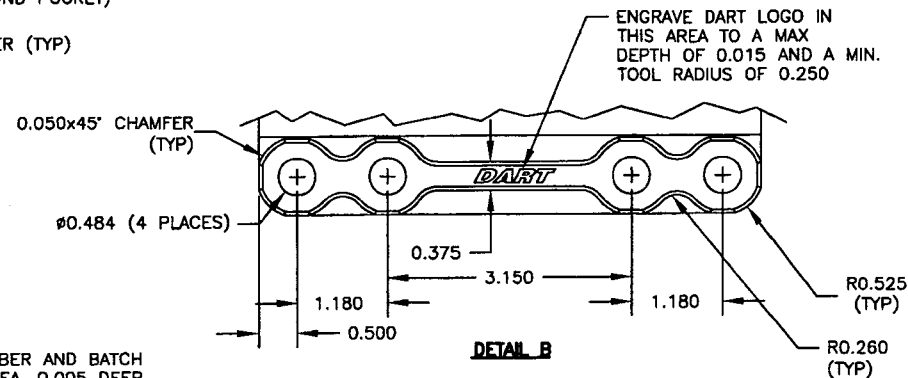
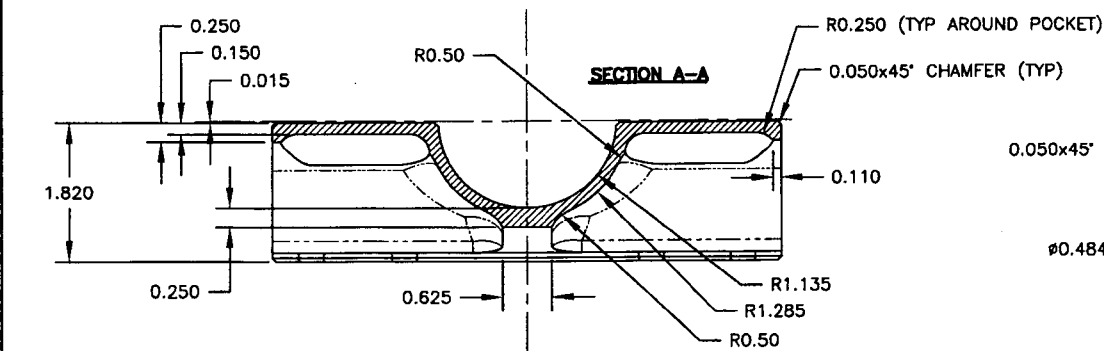
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15 #

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SUBJECT TO AMENDMENT

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C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	GP	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	06.06.30	TITLE SADDLE
		DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
		DRAWING NO. D3500
		REV. C
		SHEET 1 OF 1
		SCALE
		2:3

WITHOUT NOTICE
WORK ORDER
NO. 73409

021108131

DART AEROSPACE LTD		Work Order:	73406
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5 A	6 Z	7 3	8 A		
A	0.483	0.490		.484	.484	.484	.484	50	11.12.17
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.501	.501	.501	.501		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.248	.248	.248	.248		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.513	6.513	6.513	6.513		
P	5.990	6.010		6.002	6.002	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.554	.554	.554	.554		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.613	.613	.613	.613		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	.252		
AG	0.140	0.160		.152	.152	.152	.152		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.155	.155	.155		
Accept/Reject									

Measured by:	SK / B.A
Date:	11.12.17

Audited by:	120
Date:	11.12.17

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD		Work Order:	73406
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13 1	14 2	15 3	16 4	By	Date
A	0.483	0.490		.484	.484	.484	.484	RL	11/12/25
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.501	.501	.501	.501		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.247	.248	.248	.248		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.002	6.002	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.554	.554	.554	.554		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	.252		
AG	0.140	0.160		.152	.152	.152	.152		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.155	.155	.155		
Accept/Reject									

Measured by:	RL/K.A
Date:	11/12/25

Audited by:	RL
Date:	11-12-28

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD				Work Order: 73406	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500				Rev: C	
				Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	3/9	3/10	3/11	3/12		
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.380	.380	.380	.380		
F	0.490	0.510		.499	.499	.499	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5916	1.5913	1.593	1.591		
J	0.240	0.260		.246	.249	.246	.246		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.002	6.008	6.005	6.004		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.554	.554	.552		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.1368	1.1368	1.1388	1.1369		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.631	.631	.630	.630		
AD	0.240	0.260		.252	.253	.251	.252		
AE	1.810	1.830		1.822	1.823	1.824	1.822		
AF	0.240	0.260		.252	.253	.253	.251		
AG	0.140	0.160		.152	.154	.154	.152		
AH	0.140	0.160		.155	.155	.155	.152		
AI	0.140	0.160		.155	.153	.156	.155		
Accept/Reject									

Measured by: F.K.
Date: 11/12/24

Audited by: RP
Date: 11-12-28

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order: 7600
		73406
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.484	.484	.484	.484	BF	11/12/23
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.501	.501	.501	.501		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.246	.246	.246	.246		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.003	6.003	6.003	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.552	.552	.552	.552		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.252	.252	.252	.252		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	.252		
AG	0.140	0.160		.152	.152	.152	.152		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.155	.155	.155		
Accept/Reject									

Measured by: BF / B.A.
Date: 11.12.23

Audited by: 929
Date: 11.12.23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	